

ASAP 633-001 W Dart Aerospace Ltd.

Date: Friday, 13/06/2008 1:48:06 PM  
User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP WELDMENT		
Job Number	: 39867			Part Number	: D2563	
Estimate Number	: 10176			Drawing Number	: D2563 REV C	
P.O. Number	:			Project Number	: N/A	
This Issue	: 13/06/2008		S.O. No. :	Drawing Revision	: C	
Prsht Rev.	: NC			Material	:	
First Issue	: / /		Type :	LARGE FAB ASSY	Due Date	: 30/06/2008
Previous Run	: 37917A			Qty:	4	Um: Each
Written By	:					
Checked & Approved By	: <u>JUL 08.06.13</u>					
Comment	: Est Rev:G 02.07.31 Re-format Location RF					

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2244116	Step Extrusion	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
	1 D2244 Step Extrusion		
	Batch: <u>38023</u>		<u>SAD 08/07/24</u>
2.0	D267334	End Plate	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)	
		Pick:	
	Qty Part No. Description	Batch	
	2 D2673-34 End Cap	<u>B35887</u> ✓	
3.0	D2561	Lug	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)	
		Pick:	
	Qty Part No. Description	Batch	
	2 D2561 Lug Plate	<u>B37153</u> ✓	
4.0	D2564	Mounting Angle	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)	
		Pick:	
	Qty Part No. Description	Batch	
	2 D2564 Mounting Angle	<u>D38026</u> ✓	
		SP 08.09.05	
		SP 08.09.05	
		SP 08.09.05	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 39867

Part Number: D2563

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 LARGE FAB 1



LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

-1-Cut D2244 to 89.70" at 34 deg as per dwg D2563

2-Deburr ends

SAD 08/09/29 (4)

3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343

A/R AL ROD Batch: BM108350

M108037



4- Grind

SAD 08/09/08 (4)

SP 08.09.



6.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

S 08.09.09 (4)

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08.09.09 (4)

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 08/09/09 (4)

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 08.09.09 (4)

4

10.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Inspect for foreign object per QSI 024

2-Weld Remaining End as per Dwg D2563 using DT 8343

A/R AL ROD Batch: M108037

SP 08.09.09 (4K)

3-Grind SP 08.09.09 (4)

SAD 08/09/10 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 13/06/2008 1:48:07 PM  
User: Julie Lecocq

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 39867

Part Number: D2563

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-09-10 (4)

12.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08-09-10 (4)

13.0 POWDER COATING

POWDER COATING

+pressure wash M 08-09-10  
M 108523



Comment: POWDER COATING

Touch up Alodine then

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

→ FX 08/09/10 (4)

START TIME: 8:30AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 9:00AM

HAND FINISHING RESOURCE #1



M 108492

(4)

Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2563 and QSI 005 4.4

FX 08/09/10 (4)

14.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



M 108492

(4)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

15.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



8/9/10 su

(4)

Comment: FINAL INSPECTION/W/O RELEASE

16.0 QC21

FINAL INSPECTION/W/O RELEASE



08/09/10 (4)

Job Completion



PPP 40083

8/9/10 54

4x

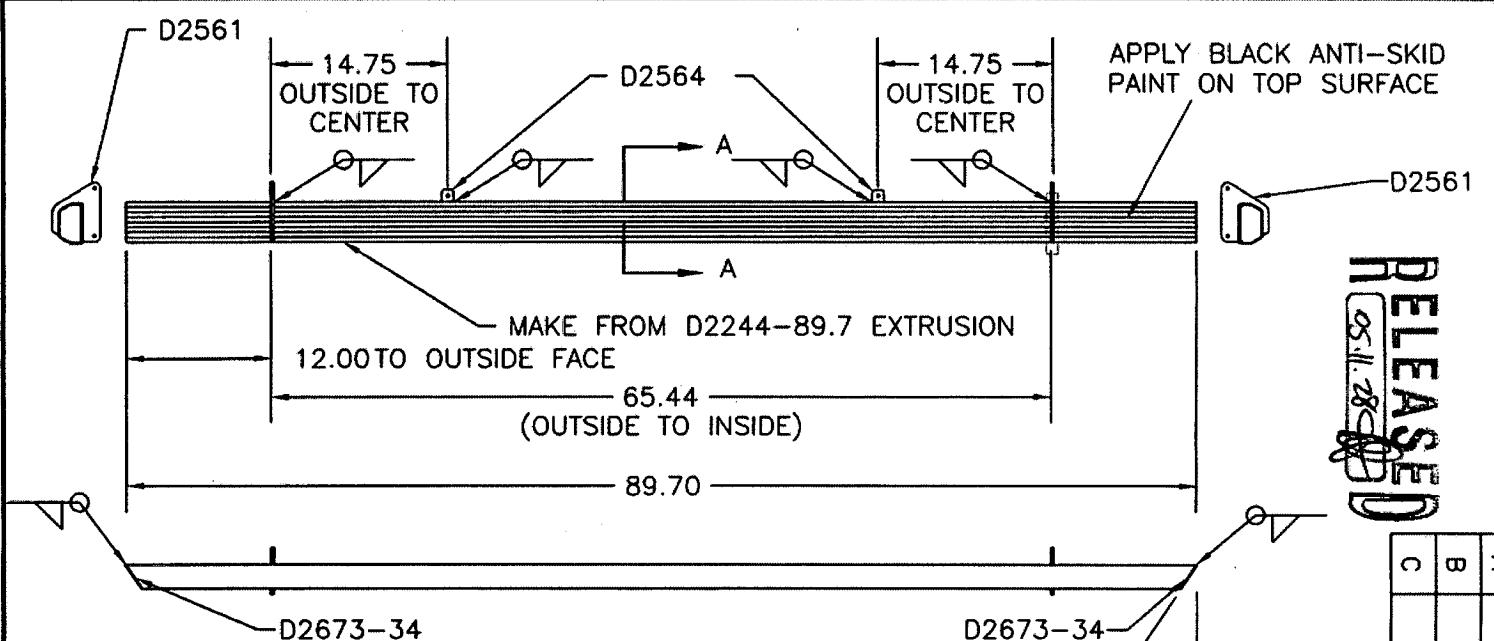
Wst, RWD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



### D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

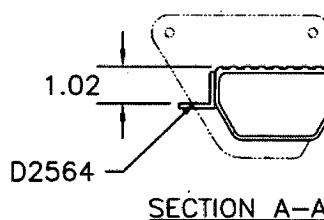
\*

cut per drawing

### D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE  
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER



RELEASED  
R  
05.11.28  
05.11.28

DESIGN BW	DRAWN BY <i>PF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MF</i>	APPROVED <i>MF</i>	DRAWING NO. D2563	
DATE 05.11.14	TITLE STEP WELDMENT ASSEMBLY	REV. C SHEET 1 OF 1 SCALE 1:15	
A	96.04.26	NEW ISSUE	
B	97.05.14	END CAPS CHANGED (WAS D2248)	
C	05.11.14	UPDATE NOTES	